

Date: Tuesday, 22/05/2007 10:12:35 AM
User: Linda Lacelle











Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : X-TUBE 412 |
| Job Number : 32447 | |
| Estimate Number : 12727 | |
| P.O. Number : <i>N/A</i> | Part Number : D412664245 |
| This Issue : 22/05/2007 S.O. No. : <i>N/A</i> | Drawing Number : D412-664-245 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : LANDING GEAR | Drawing Revision : C |
| Previous Run : 32446 | Material : <i>N/A</i> |
| Written By : _____ | Due Date : 15/06/2007 Qty: 1 Um: Each |
| Checked & Approved By : _____ | |
| Comment : Est Rev: A New Issue 07-02-14 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | DC | DOCUMENT CONTROL |
| |  |  |
| Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD412-664-205 CHG001 | | |
| 2.0 | D6009129 | Crosstube Material |
| |  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <i>26548</i> Check OD = 3.500"; ID = 2.250" | | |
| 3.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
| |  |  |
| Comment: 1-TURN AS PER FOLIO FA690 & DWG D412-664-245, FOLIO REV: <i>AS</i> DWG REV: <i>C</i> 2-DEBURR AS REQUIRED | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | QC8 | SECOND CHECK |
| |  |  |
| Comment: SECOND CHECK | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: X-TUBE 412

Job Number: 32447

Part Number: D412664245

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|-------------------------|
| 6.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Job 7-5-28

| | | |
|-----|-----|------------------------------|
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-28

| | | |
|-----|-----------------|----------------------------|
| 8.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Job 7-5-28

| | | |
|-----|-----|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-5-29

| | | |
|------|-----|------------------------------|
| 10.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-29

| | | |
|------|---------|-----------------|
| 11.0 | BENDING | BENDING MACHINE |
|------|---------|-----------------|



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

ELV 7-5-30

| | | |
|------|------|------------------------------|
| 12.0 | QC15 | DIMENSIONAL CHECK OF X-TUBES |
|------|------|------------------------------|



Comment: DIMENSIONAL CHECK OF X-TUBES

24.06.04

| | | |
|------|----------------|-------------------------|
| 13.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|------|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Mark cut lines as per dwg D412-664-245

2-Cut tube as per dwg D412-664-245

3-Deburr and engrave part#/batch# per dwg

DP 7-6-4 1507-6-5

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Drawing Name: X-TUBE 412

Job Number: 32447

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

Jb 7-6-5

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES-LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3908 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207106106 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0

D36061

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CUFF

Batch: B31635

21.0

CR3212407

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

CHERRY RIVET

Batch: M104071

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number: 32447

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill Rivet holes as per Dwg D412-664-245 DT8972
 - 2-Drill pilot holes in tube as per Dwg D412-664-245
 - 3-Ream hole to finish size in tube as per Dwg D412-664-245
 - 4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245
 - 5-Chemical conversion coat per dwg and QSI 005
 - 5-Rivet Cuffs as per Dwg D412-664-245. with Sika flex in Between tube & Cuff
- A/R SIKAFLEX -241/-291 BATCH: M104732

DP
7-6-25

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

22-06-26 @

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

- 1-Prime inside and outside crosstube as per QSI 005 4.2
- 2-Paint outside crosstube with White Imron as per QSI 005 4.2

} DT 07-07-09
(PTC)

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

22-07-13 @

26.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Chafing Shield

Batch: B 30201

ml 07 07 14

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: D412-664 245 PAR #: N/A Fault Category: Prod - Finish NCR: Yes No DQA: RA Date: 07.07.18
 QA: N/C Closed: RA Date: 07.07.18

| NCR: <u>32447</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|-------------|---|---------------------------------------|---------------------------------------|------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
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| <u>07.07.12</u> | <u>24.0</u> | <u>Primer was visible on the tube</u> <u>R.C: Paint was missed on a section; human error</u> | <u>[Signature]</u> <u>05/07/12</u> | <u>Stand and reinspect per Q51005</u> | <u>ML</u> <u>07.07.12</u> | <u>[Signature]</u> <u>07.07.13</u> | <u>[Signature]</u> <u>05/07/12</u> | <u>[Signature]</u> <u>07.07.12</u> |
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Drawing Name: X-TUBE 412

Job Number: 32447

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.0536 sf(s)

Rubber Cushion

Cut to .630" X 5.7" X 2PCS

Batch: 32844

MT 07 07 16

28.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

30200

RT 07-07-14

29.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

2 X D2856-600-1009

Batch: 26650

MT 07 07 14

30.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

103896

MT 07 07 14

31.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 101568

RT 07-07-14

32.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-245

Install Chaffing Sheilds

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 32447

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

Instal support with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: 200

Batch: 104723

} 8T 07-07-14

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/16 (X1)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-205

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 1:15 7/7/16

Location:

PPP Rev: PPP 32188

LC

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
R 07/07/23

Job Completion



U 07-07-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>QP</i> | DRAWN BY <i>QP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D412-664-245 | REV. C SHEET 1 OF 3 |
| DATE 07.03.29 | | TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS | |
| A | 06.12.01 | NEW ISSUE | |
| B | 07.03.01 | CHG CUFF AREA, CHG RUBBER CUSHION | |
| C | 07.03.29 | CHG RIVET AND RUBBER CUSHION | |

RELEASED07.04.24 *[Signature]***PARTS LIST:**

| Qty | Part Number | Description |
|-----|-------------------|---|
| X | D412-664-245 | CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT) |
| 1 | D6009-129 | CROSSTUBE |
| 2 | D2856-600-1009 | ABRASION STRIP |
| 1 | D2896-1 | SUPPORT |
| 2 | D3189-1 | CHAFING SHIELD |
| 2 | D3595-063-570 | RUBBER CUSHION |
| 2 | D3606-1 | CUFF |
| 44 | CR3212-4-07 | RIVET (OR M7885/3-4-07) |
| 4 | MS21920-28 | CLAMP |
| 2 | MS21920-30 | CLAMP (OR MS21920-32) |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
| A/R | SIKAFLEX-241/-291 | SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT) |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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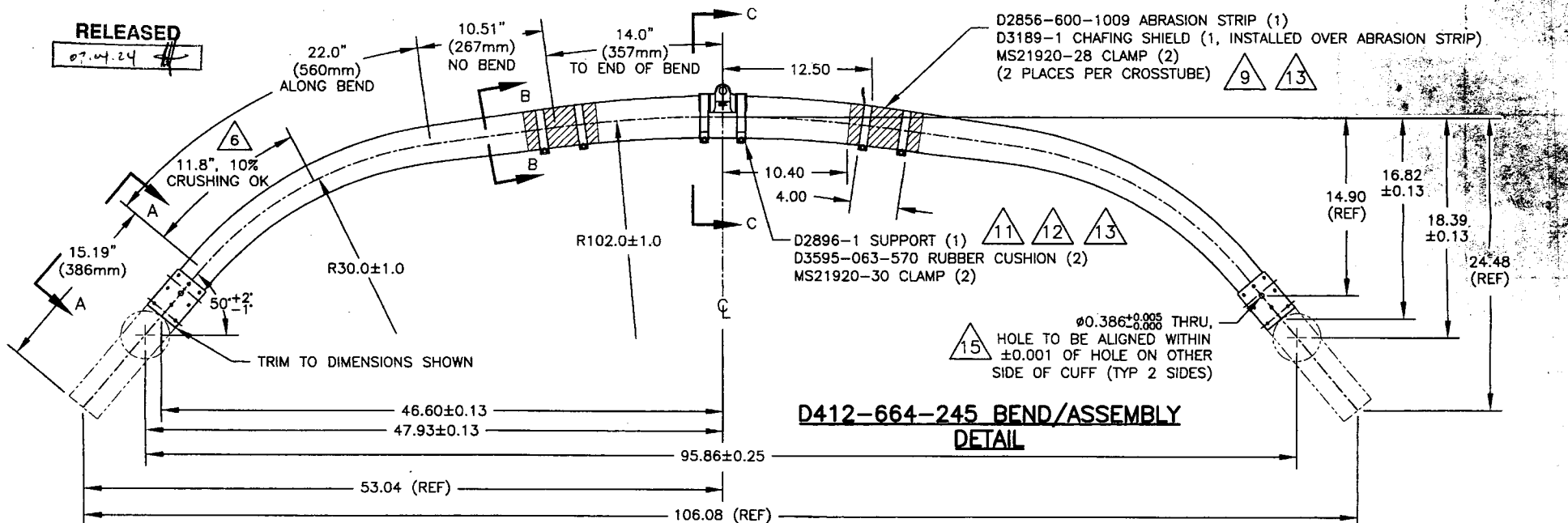
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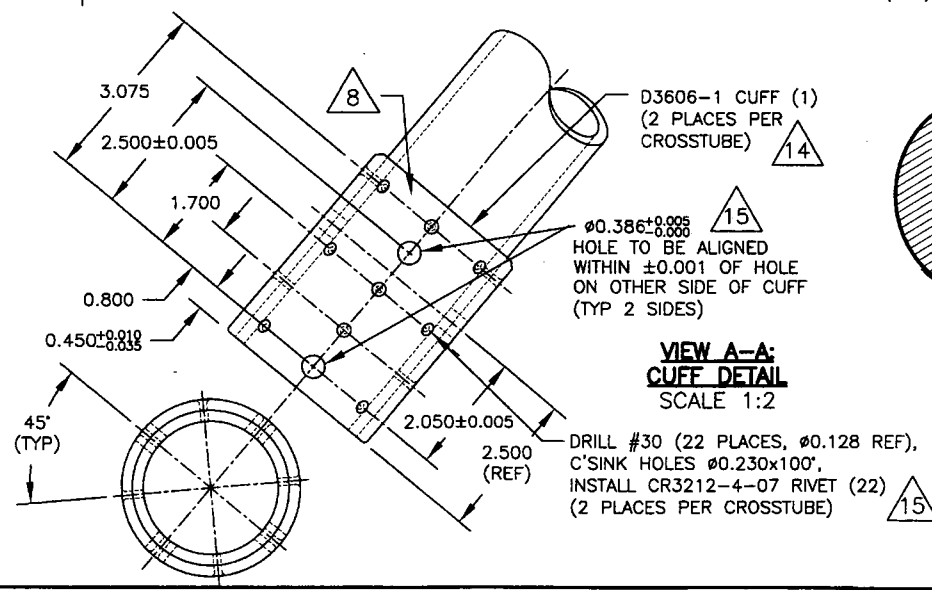
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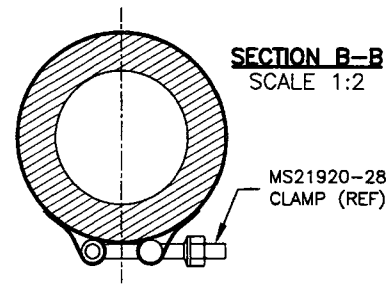
RELEASED



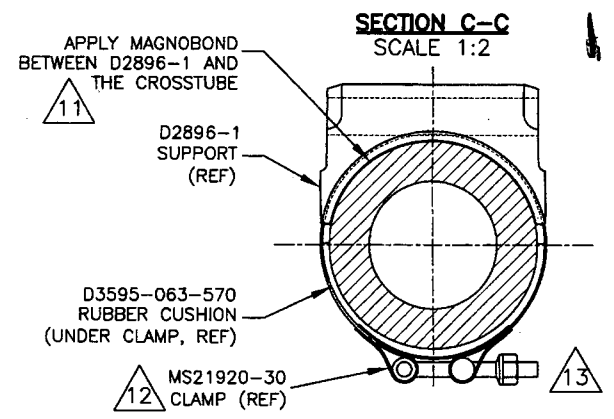
**D412-664-245 BEND/ASSEMBLY
DETAIL**



**VIEW A-A:
CUFF DETAIL
SCALE 1:2**



**SECTION B-B
SCALE 1:2**



**SECTION C-C
SCALE 1:2**

| | | | |
|---|----------|-------------|--------------------------------|
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| DESIGN | qj | DRAWN BY | qj |
| CHECKED | qj | APPROVED | qj |
| DATE | 07.03.29 | DRAWING NO. | D412-664-245 |
| | | TITLE | CROSSTUBE (412 LOW-NARROW AFT) |
| | | SCALE | 1:8 |

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DART AEROSPACE LTD.
WINDSOR, ONTARIO, CANADA
REV. C
SHEET 2 OF 3

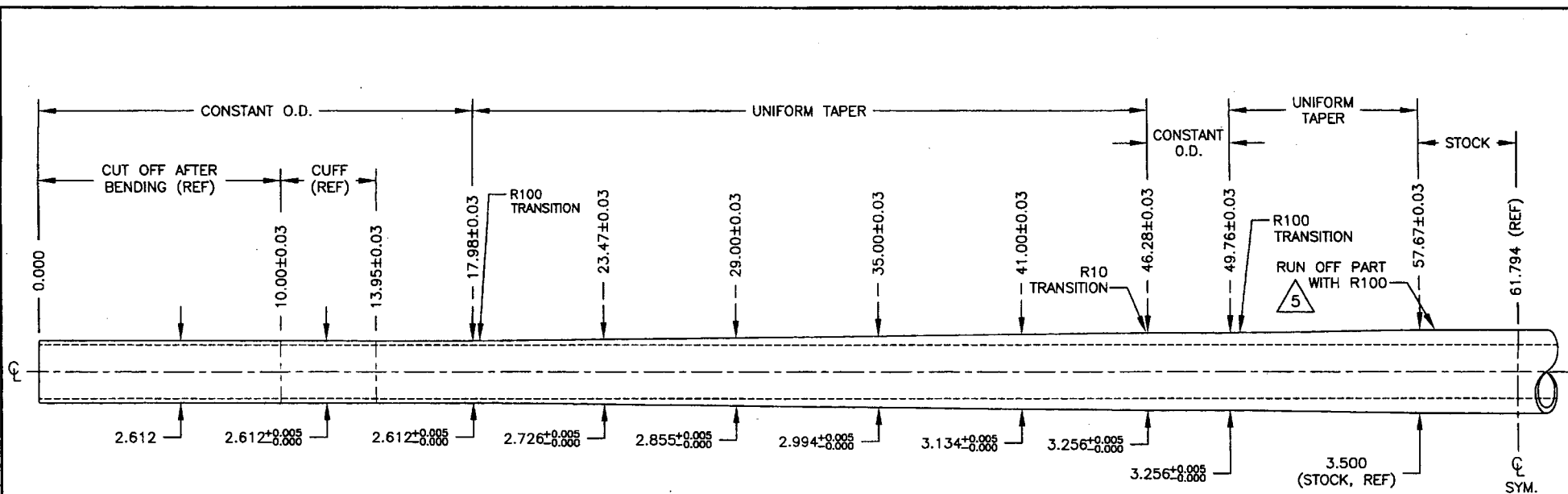
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NOTE: Date & initial all entries



D412-664-245 MACHINING DETAIL

RELEASED

07 04 19

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|--|--|----------|----------|--------------------------------|---|
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| | | DATE | | D412-664-245 | SHEET 3 OF 3 |
| | | 07.03.29 | | TITLE | SCALE |
| | | | | CROSSTUBE (412 LOW-NARROW AFT) | 1:4 |

| | | |
|-----------------------------------|--|-------------------------|
| DART AEROSPACE LTD | | Work Order: 1332447 |
| Description: X70BP 412 | | Part Number: 0412664245 |
| Inspection Dwg: 0412664245 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

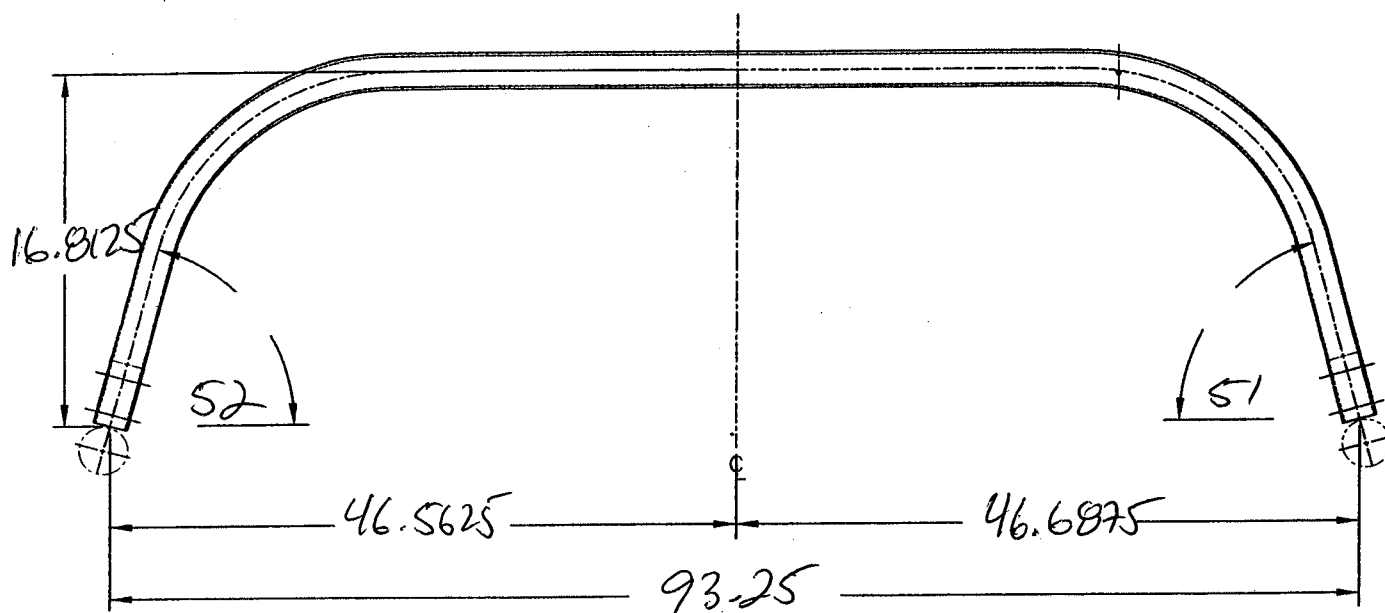
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------------|------------------|--------|--------|----------------------|----------|
| 2.612 | +0.005 -0.000 | 2.615 | ✓ | | | |
| 2.612 | " | 2.615 | ✓ | | | |
| 2.726 | " | 2.726 | ✓ | | | |
| 2.855 | " | 2.855 | ✓ | | | |
| 2.994 | " | 2.994 | ✓ | | | |
| 3.134 | " | 3.134 | ✓ | | | |
| 3.256 | " | 3.256 | ✓ | | | |
| 3.256 | " | 3.256 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| 2.612 | " | 2.615 | ✓ | | | |
| 2.612 | " | 2.615 | ✓ | | | |
| 2.726 | " | 2.726 | ✓ | | | |
| 2.855 | " | 2.855 | ✓ | | | |
| 2.994 | " | 2.994 | ✓ | | | |
| 3.134 | " | 3.134 | ✓ | | | |
| 3.256 | " | 3.256 | ✓ | | | |
| 3.256 | " | 3.256 | ✓ | | | |
| | | | | | | |
| 123.58 | ±0.030 | 123.600 | ✓ | | | |

| | | |
|--------------------|----------------|---------------------|
| Measured by: J. J. | Audited by: ML | Prototype Approval: |
| Date: 07/05/25 | Date: 07/05/28 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

| | | | |
|---|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 32447 |
| Description: Crosstube Low Narrow Aft (412) | | Part Number: | D412-664-205 |
| Inspection Dwg: D412-664-245 Rev: C | | Page 1 of 1 | |

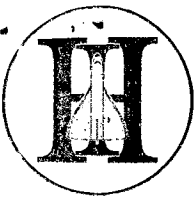
| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 16.69 | 16.95 |
| 1/2 Span | 46.47 | 46.73 |
| Angle | 49° | 52° |
| Total Span | 92.94 | 93.46 |



| Comments |
|----------|
| |
| |
| |
| |

| | |
|-----------------|--------------------------------|
| QC15 Inspection | <i>[Signature]</i> 0706.041 |
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.04.27 | New Issue | KJ/JM | |



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36580

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B31356.

Qty (1) P/N D412-664-203 S/N B30186.

Qty (2) P/N D212-664-201 S/N's B30423 and B30421.

Qty (3) P/N D412-664-245 S/N's B32445 B32447 and B32446.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(7) cross tubes inspected. (7) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE June 06, 2007

INSPECTION
STAMP(S) 

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003908

Linda Lacelle

ADDRESS:

CONTACT NAME:

| | | |
|-----------------|---|-----|
| LABOUR | @ | \$ |
| MATERIALS | @ | |
| TRAVEL EXPENSES | @ | GST |
| HOTEL EXPENSES | @ | PST |

INVOICE NO.


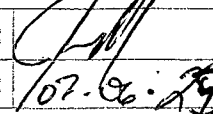
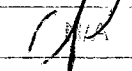
TOTAL \$

| | | |
|---|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 32447 |
| Description: Bearpaw Cuff 5'g / CF412 AFT DT8972 | | Part Number: D412-664-245 |
| Inspection Dwg: D412-664-245 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|----------------------------|---------------------|--------|--------|-------------------------|----------|
| A 0.450 | ± 0.010 ± 0.035 | 0.460 | | | | |
| B 0.800 | 0.001 | 0.800 | | | | |
| C 1.700 | 0.001 | 1.700 | | | | |
| D 3.075 | 0.001 | 3.070 | | | | |
| E | | | | | | |
| F | | | | | | |
| G | | | | | | |
| H | | | | | | |
| I | | | | | | |
| J | | | | | | |
| K | | | | | | |
| L | | | | | | |
| M | | | | | | |
| N | | | | | | |
| O | | | | | | |
| P | | | | | | |
| Q | | | | | | |
| R | | | | | | |
| S | | | | | | |
| T | | | | | | |
| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

| | | |
|--|---|---|
| Measured by:  | Audited by:  | Prototype Approval:  |
| Date: 7-6-25 | Date: 107.06.25 | Date: 107.06.25 |
| Rev: A | Date: 04.01.09 | Change: New Issue |
| Revised by: KJ/RF | Approved: | |